

Work Order ID 88058

Tuesday, July 24, 2012 10:33:14 AM

88058

Page 1

Item ID: PB67-43001-37

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube Arm Assembly

Start Date: 7/24/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/3/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: CMF Date: 12-07-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	c

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble by drilling thru both -125 and -343 as per dwg
2- install spring slotted pin as per dwg

①

φ

Ac

12.07.30

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

SMB

12.7.31

DAS
16
8-89

12/13/1

1

120

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11h10
OVEN TEMPERATURE: 320°F
FINISH TIME: 11h40

m18144

1

2

SP

12/08/02

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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NCR: Yes / No

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Picklist Print

Tuesday, July 24, 2012 10:33:14 AM

Page 1

Work Order ID: 88058

Parent Item: PB67-43001-37

Parent Item Name: Tube Arm Assembly

Start Date: 7/24/2012

Required Date: 8/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	163.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				122089		84							
				<u>122089</u>		84							
				ST400		79							
				115827		79							
PB67-43001-125 Clevis		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		1							
				23993		1							
PB67-43001-343 Tube Arm		Manufactured	No			100	Each	9.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST432		9							
				<u>41213</u>		6							
				41507		3							

12/17/300

NCR: Yes / No

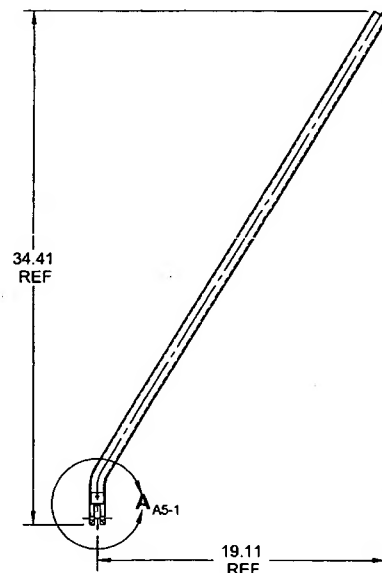
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ITEM	QTY -37	P/N	DESCRIPTION
1	X	B67-43001-37	TUBE ARM ASSEMBLY
3	1	B67-43001-343	TUBE ARM
4	1	B67-43001-125	CLEVIS
5	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-37 TUBE ARM ASSEMBLY

8 MS171534
SPRING SLOTTED
TENSION PIN

0.50

B67-43001-343
TUBE ARM

B67-43001-125
CLEVIS 8

9

DETAIL A B7-1
SCALE 4 X

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.81 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-125 ON B67-43001-343 AS SHOWN AND DRILL A $\phi 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-125 TO B67-43001-343 USING MS171534 SPRING SLOTTED TENSION PIN
- 9) MASK PRIOR TO POWDER COAT

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	AD		
APPROVED	AD		
DE APPR.	N/A		
DATE	09.06.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. B67-43001-37 REV. C
SHEET 1 OF 1

TITLE TUBE ARM ASSEMBLY SCALE NTS

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NCR: Yes / No

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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other